

Date: Wednesday, 5/10/2006 9:18:23 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	BASKET BASE ASSEMBLY (350)			
Job Number	27048A	Part Number	D2221			
Estimate Number	10189	Drawing Number	D2221/D2235			
P.O. Number	N/A	Project Number	N/A			
This Issue	5/10/2006	S.O. No.	N/A			
Prsht Rev.	NC	Type	LARGE FAB ASSY			
First Issue	N/A	Material	N/A			
Previous Run	27047A	Due Date	5/30/2006	Qty:	1	
Written By	<i>See Comment Below</i>					Um: Each
Checked & Approved By	<i>106.05.10 D</i>					
Comment	Est Rev:J 05.09.02 Added D3442-1KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D31661	Basket Hoop		
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
		Pick:		
		Qty Part Number Description Batch		
		4 D3166-1 RIB <i>326717</i>		<i>CPL 06.05.17</i>
2.0	D22323	Basket Hinge		
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
		Pick:		
		Qty Part Number Description Batch		
		2 D2232-3 Hinge bracket <i>324527</i>		<i>CPL 06.05.23</i>
3.0	D2325	Support Gusset (350 Bask)		
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
		Pick:		
		Qty Part Number Description Batch		
		4 D2325 Support Gusset <i>326922</i>		<i>CPL 06.05.18</i>
4.0	D23273	Spacer Bushing		
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
		Pick:		
		Qty Part Number Description Batch		
		2 D2327-3 Bushing <i>325823</i>		<i>CPL 06.05.18</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

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Process Sheet

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Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 27048A

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D2581 Mounting Bracket

326204

CPL 06-05-18

6.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 D3442-1 Shim

326739

CPL 06-05-18

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 39.6900 sf(s)/Unit Total : 39.6900 sf(s)

Pick:

Qty Part Number Description Batch
36 sf M304EX0.75-16F Expanded Metal

M100981

CPL 06-05-23

8.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: *M100704 → 37.76"*

M100704 → 37.76"

CPL 06-05-17

9.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

CPL 06-05-29

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

W/O:		WORK ORDER CHANGES					
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/06/19

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/10/2006 9:18:23 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 27048A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0 QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

PD 06-05-29 (1)

11.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/06/08 (1)

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with white sikaflex-291 Batch: M101193 SP m. P.

Expiry date: 11/2006

06/06/15

14.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/06/15 (1)

Job Completion



U 06/06/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART

DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS

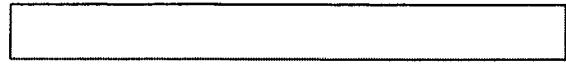
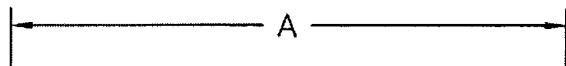
RELEASED

05.08.19 *[initials]*

C	95.11.21	SEPARATE BASKET AND LID
D	96.06.21	CHANGE LATCH
E	01.04.19	CHANGE HINGE
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



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D2221-1/-3/-5/-7

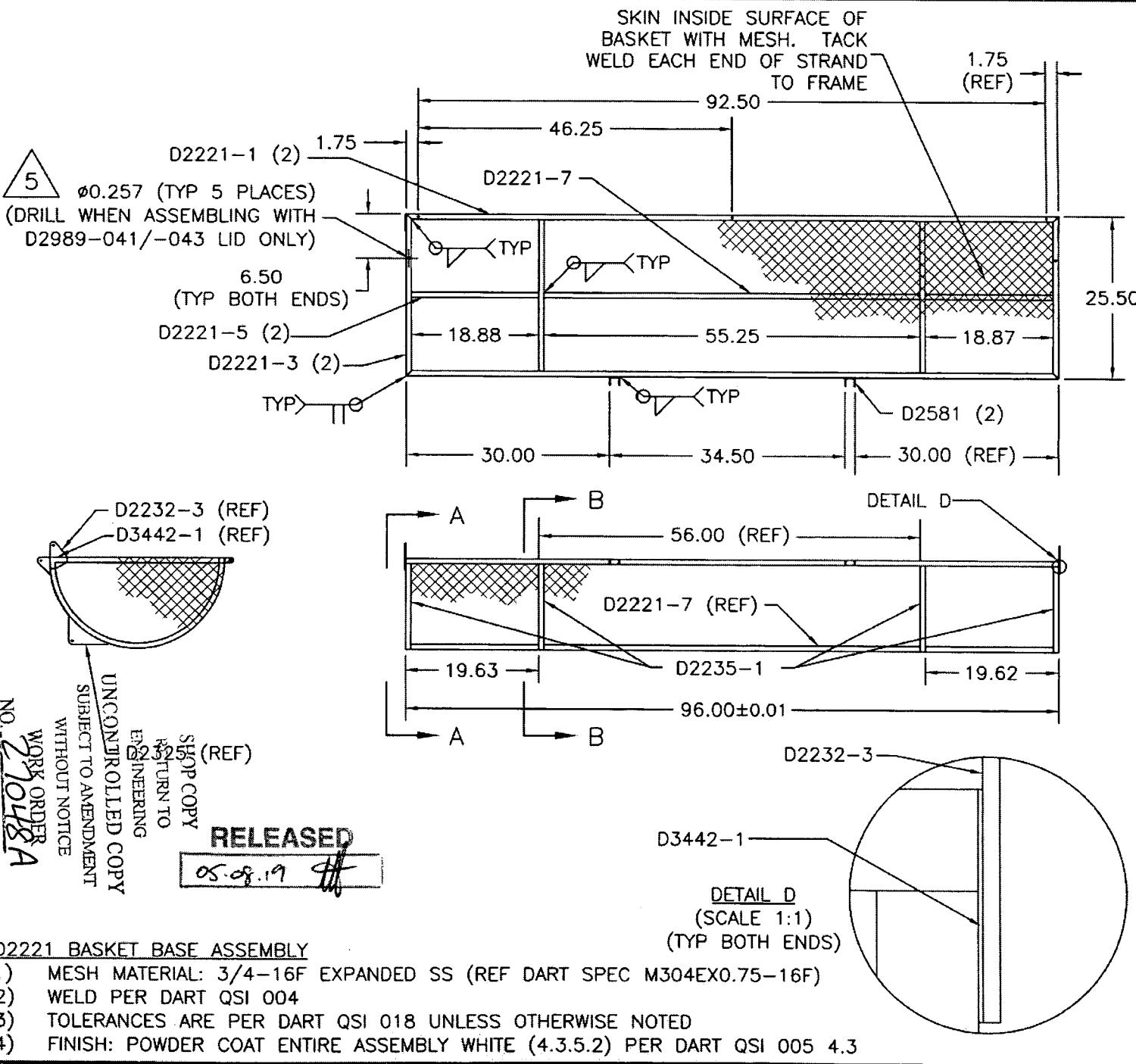
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING (REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID

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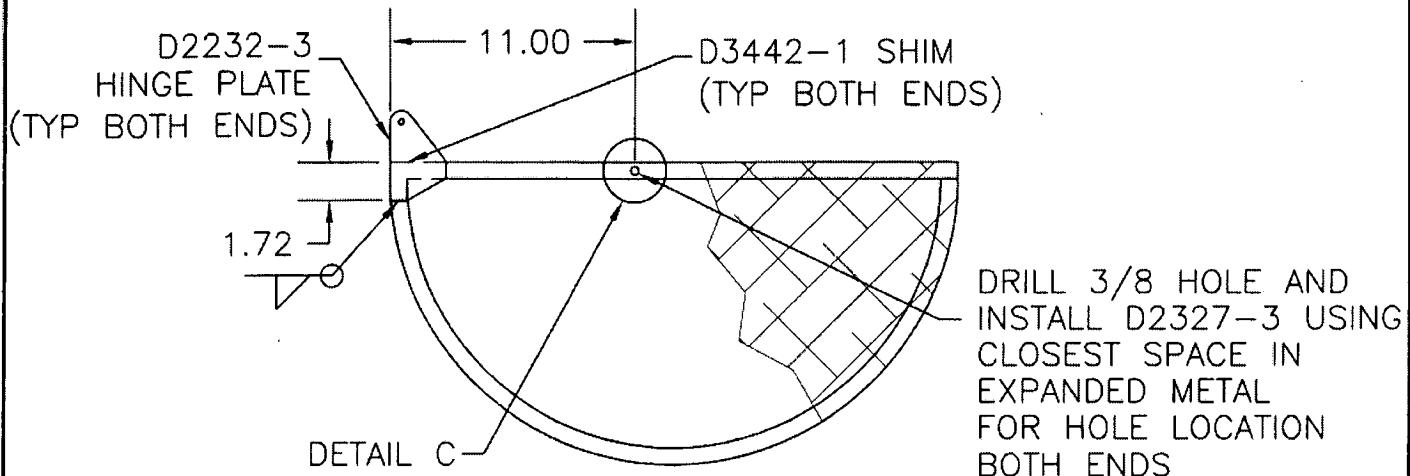
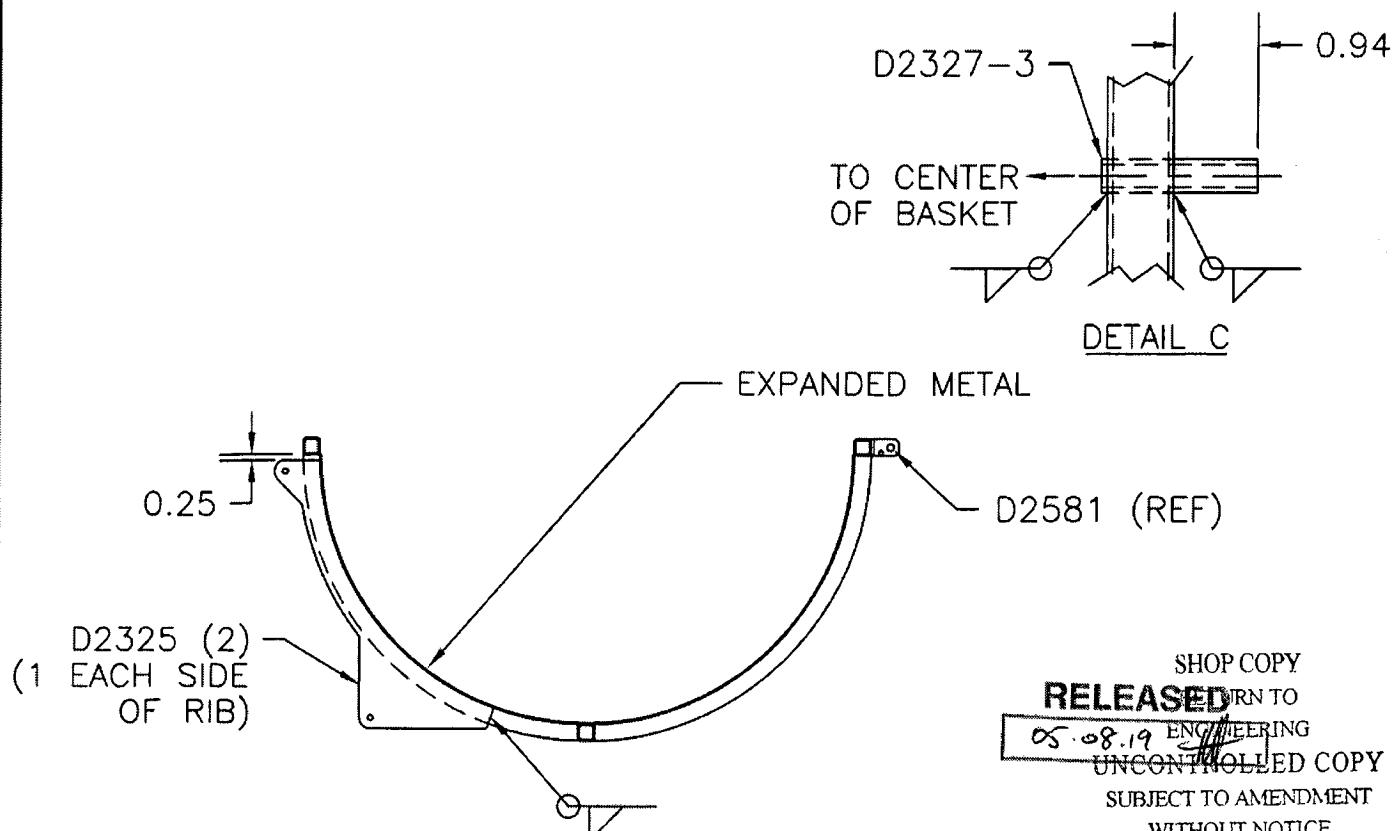
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DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2221	HAWKESBURY, ONTARIO, CANADA
DATE 05.06.07	TITLE BASKET BASE ASSEMBLY (350)	SHEET 2 OF 3	REV. F



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DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8

SECTION A-A SAME BOTH END RIBSSECTION B-B SAME BOTH CENTER RIBS

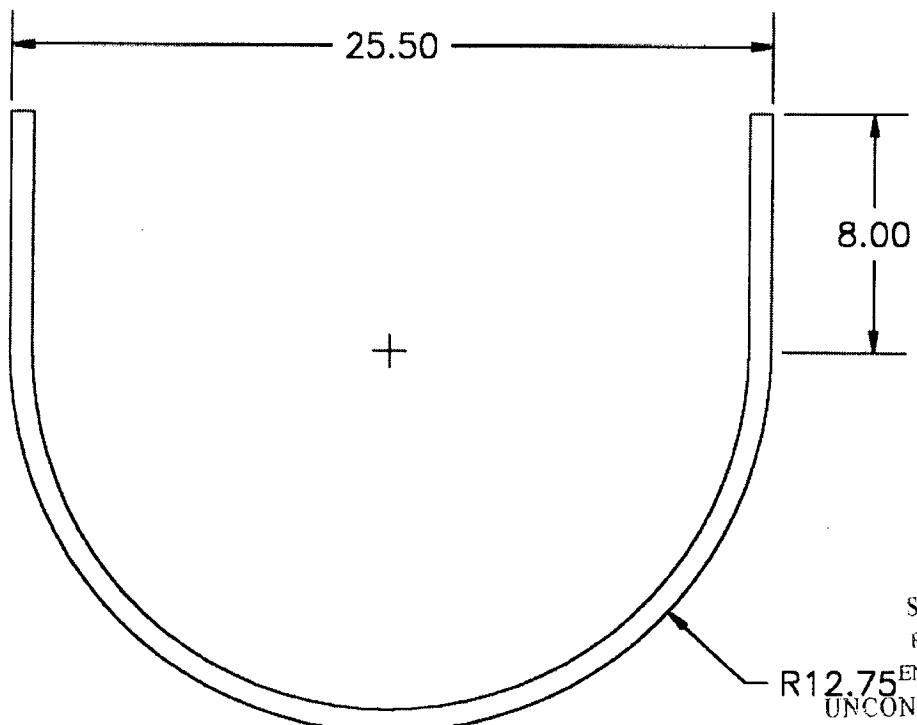
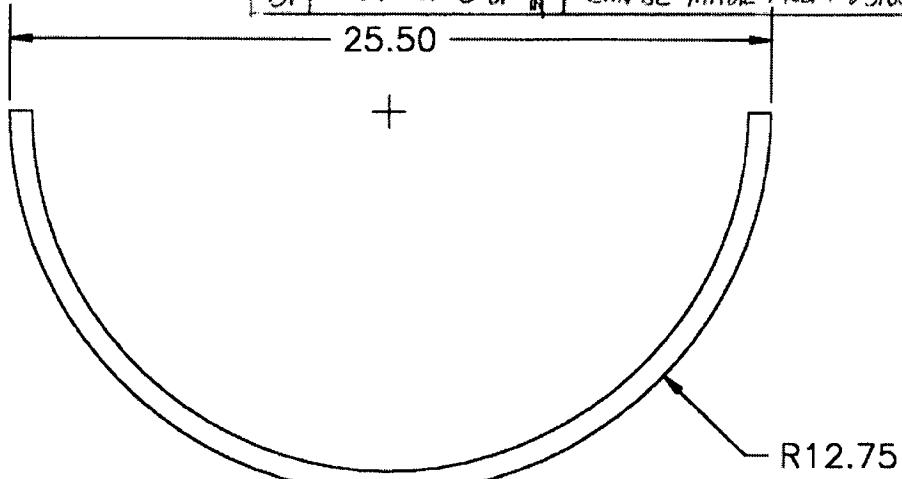
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DART

DESIGN B. WILLIAMS	DRAWN BY B. WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2235
DATE 94:12:16		REV. B SHEET 1 OF 1
		TITLE BASKET RIBS
BI	02.08.06 <i>P#</i>	CAN BE MADE FROM D3166-1

RELEASED
19605007

CAN BE MADE FROM D3166-1 BI
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR. NO. 27048A

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